



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4894-1

Job Sheet 172987



Part No: D4894-1

Job Qty: 4 ea

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP REV:A 13.05.27 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	3/2/18		0.00	0.00	Start Up Waterjet		ac 18/03/21
100	Waterjet	4 pcs	3/3/18		0.00	9.52	Waterjet1		de 18/03/21
110	QC	4 pcs	3/3/18		0.00	0.00	QC2 Waterjet-1		de 18/03/21
114	Mill Conv	4 pcs	3/3/18		0.00	6.25	Mill Conv 1		J.C.V.
116	QC	4 pcs	3/3/18		0.00	0.00	QC2 Machining-3		J.C.V. 18-04-04
120	QC	4 pcs	3/3/18		0.00	0.00	QC8 Machining-3		EX 18/04/24
130	HandFinish	4 pcs	3/3/18		0.00	0.78	HandFinish1		BEB 18/04/25
131	Powdercoat	4 pcs	3/5/18		0.00	0.59	Powdercoat1		BR 18/04/25
132	QC	4 pcs	3/5/18		0.00	0.00	QC3		11 APR 2018
140	QC	4 pcs	3/5/18		0.00	0.00	QC5		11 APR 2018
150	Packaging	4 pcs	3/5/18		0.00	0.00	Packaging3-2		11 APR 2018
160	QC21-SA	4 Ea	3/5/18		0.00	0.00	QC21		21 APR 2018

M138760

START: 3:20

OV.T: 3:20

FINISH: 3:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	17.5440 ft (4.386 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	18	44	0

Part Specifications

Specifications could not be found.

Plex 2/23/18 1:12 PM dart.logan.david



Container No: S053662



Part: D4894-1

Job No: 172987

Serial No/Batch: S053662

Revision:

Inspector:

DART Aerospace Ltd.
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Date: 03/21/18

240
11
171 240
171 240

DART AEROSPACE LTD		Work Order: 172987
Description: Fwd Beam		Part Number: D4894-1
Inspection Dwg: D4894	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.63	+/-0.030	52.625	✓		Tape	
19.75	+/-0.030	19.750	✓			
11.00	+/-0.030	11.000	✓			
6.50	+/-0.030	6.500	✓			
0.65	+/-0.030	0.651	✓		Caliper	JCL-08
3.50	+/-0.030	3.490	✓			
1.50	+/-0.030	1.505	✓			
6.50	+/-0.030	6.500	✓		Tape	JCL
4.35	+/-0.030	4.350	✓			
2.85	+/-0.030	2.855	✓		Caliper	JCL-08
3.80	+/-0.030	3.800	✓			
12.16	+/-0.030	12.160	✓			
4.00	+/-0.030	4.000	✓			
14.25	+/-0.030	14.250	✓		Tape	
0.60	+/-0.030	0.602	✓		Caliper	JCL-08
36.38	+/-0.030	36.375	✓		Tape	
Ø0.129	+0.005/-0.001	0.129	✓		caliper	JCL-08
1.00	+/-0.030	1.000	✓			
0.60	+/-0.030	0.602	✓			
2.300	+/-0.010	2.300	✓			
0.75	+/-0.030	0.750	✓			
1.800 Pitch	+/-0.005	1.800	✓			
3.600	+/-0.005	3.600	✓			
Ø0.377	+0.006/-0.001	0.377	✓			

Measured by: J.L. V	Audited by:	Preliminary Approval:
Date: 18-04-09	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	
B	14.09.17	Dwg Rev updated	KJ	

8 7 6 5 4 3 2 1

D

D

C

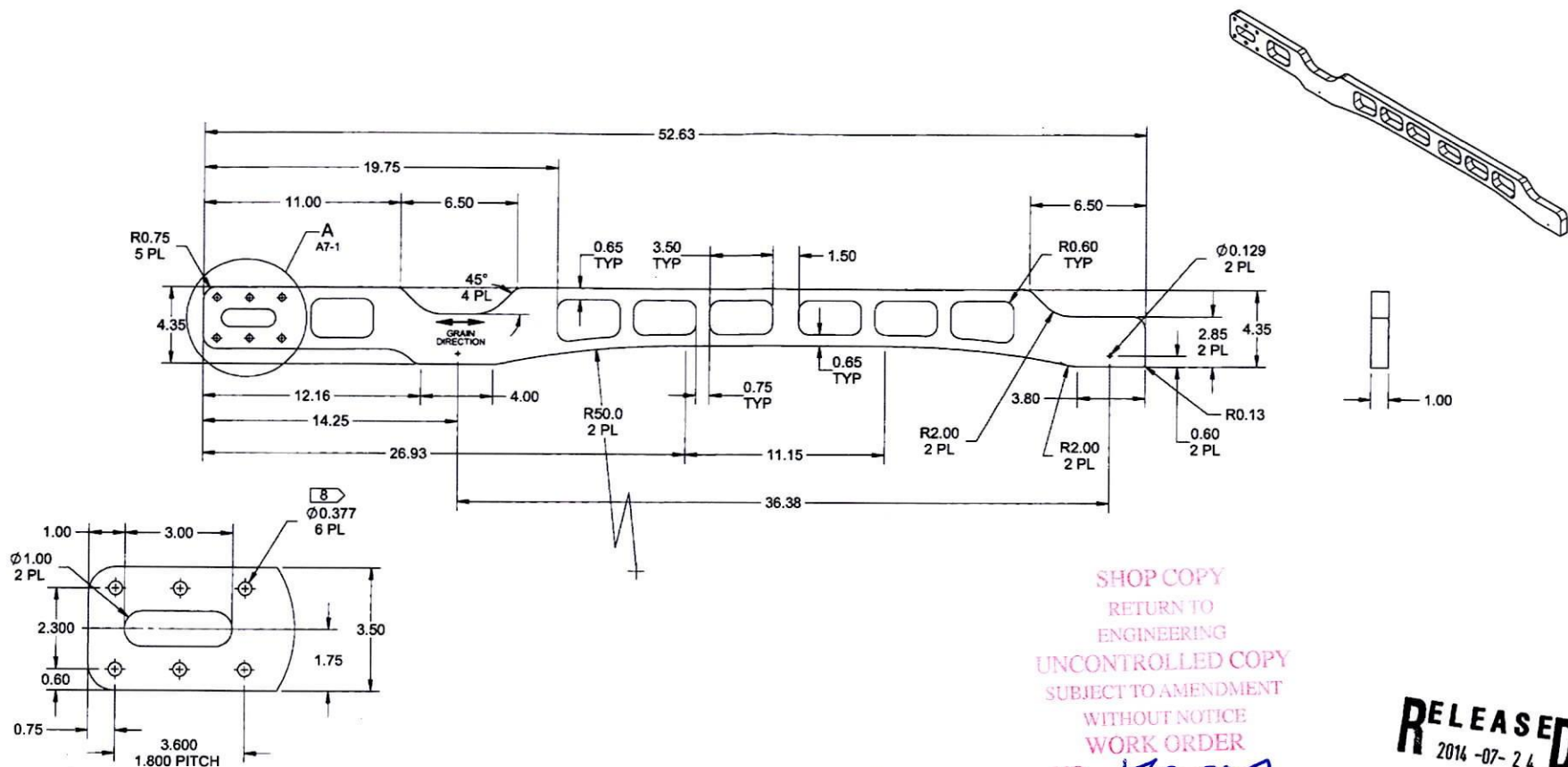
C

B

B

A

A



DETAIL A D7-1

D4894-1 FWD BEAM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 11.96 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 172987
20180226

RELEASED
2014-07-24

B	REMOVED ONE Ø0.129 HOLE FROM D4894-3 (ZN D2-2)	RF	14.06.24
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4894	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BEAM	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED

8 7 6 5 4 3 2 1